

Work Order ID 74155

Monday, September 26, 2011 10:35:21 AM

Page 1

Item ID: D3407-5

Accept



Setup Start



Revision ID:

Item Name: Ring

Stop



Start Date: 9/26/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/28/2011 Req'd Qty: 30.00

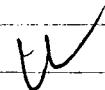


Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
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D3407	Rev E	
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100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

B1-10-13

FLOW CNC Waterjet
7-4 250X4\

1-Cut as per Dwg D3407

Dwg Rev: E

Prog Rev: E

2-Break edges on grinder as per Dwg D3407

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B1-10-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

QC8- Inspect parts - second check

0.00

8/10/26

counts
(430)

Quality Control

130

Identify as per dwg & Stock Location: *W/A*

0.00

8/10/26 (430)

Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

140



QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

*W/10/27 (4)**ME
W/10/26*

Dart Aerospace Ltd

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Picklist Print

Monday, September 26, 2011 10:35:19 AM

Page 1

Work Order ID: 74155



Parent Item: D3407-5



Parent Item Name: Ring

Start Date: 9/26/2011

Required Date: 9/28/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 05-11-22 JLM
IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000 17-4 SS Bar .250 X 4.00		Purchased		No		100	f	0.0000	0.2666	8.418947	8	11-10-12	

17-4 SS Bar .250 X 4.00



M 119101

30

Dart Aerospace Ltd

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DART AEROSPACE LTD	Work Order:	471155
Description: Tow Ring	Part Number:	D3407-5
Inspection Dwg: D3407	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

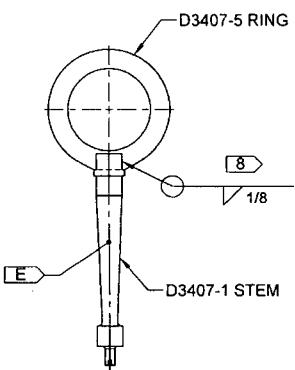
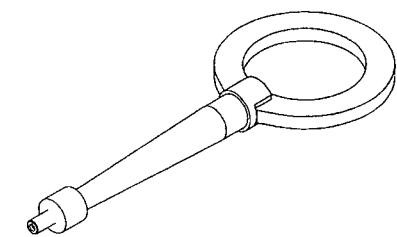
Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: 11-10-2	Date: 11/10/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.02.02	New Issue	KJ/JLM	
B	07.09.18	Tolerance revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	09.05.04	Dwg Rev updated	KJ/DD	 

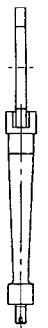
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E

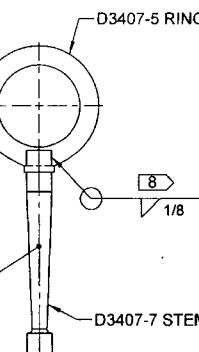
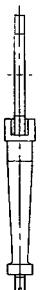
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING E

RELEASED
07-05-2018

WORLSS

A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	19	DART AEROSPACE USA, INC.	
DRAWN	RD	PORT HADLOCK, WA	
CHECKED	A	DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

D

C

B

A

Dart Aerospace Ltd

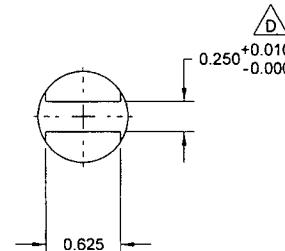
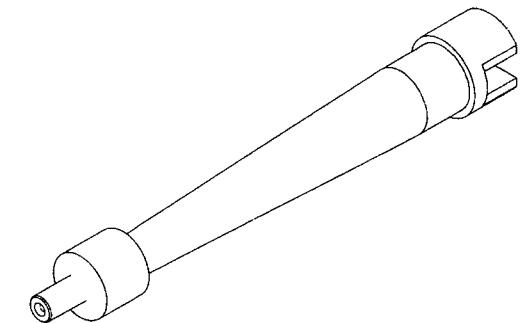
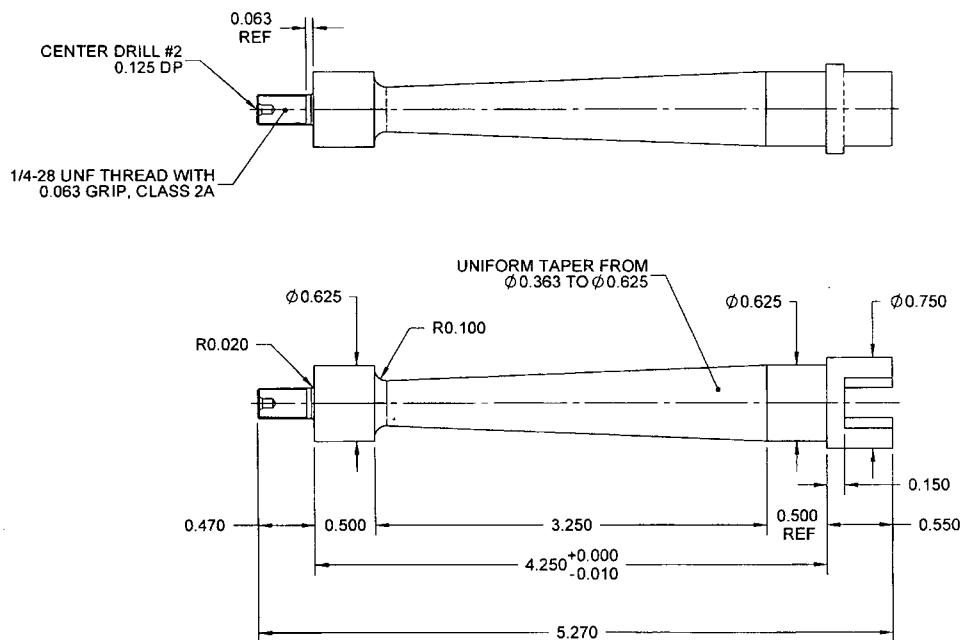
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D3407-1 STEM

RELEASED
01-05-01 1000

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN	<i>PP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	<i>PP</i>			
CHECKED	<i>PP</i>	DRAWING NO.	REV. E	
MFG. APPR.	<i>PP</i>	D3407	SHEET 2 OF 5	
APPROVED	<i>PP</i>	TITLE	SCALE	
DE APPR.	<i>PP</i>	TOW RING	NTS	
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

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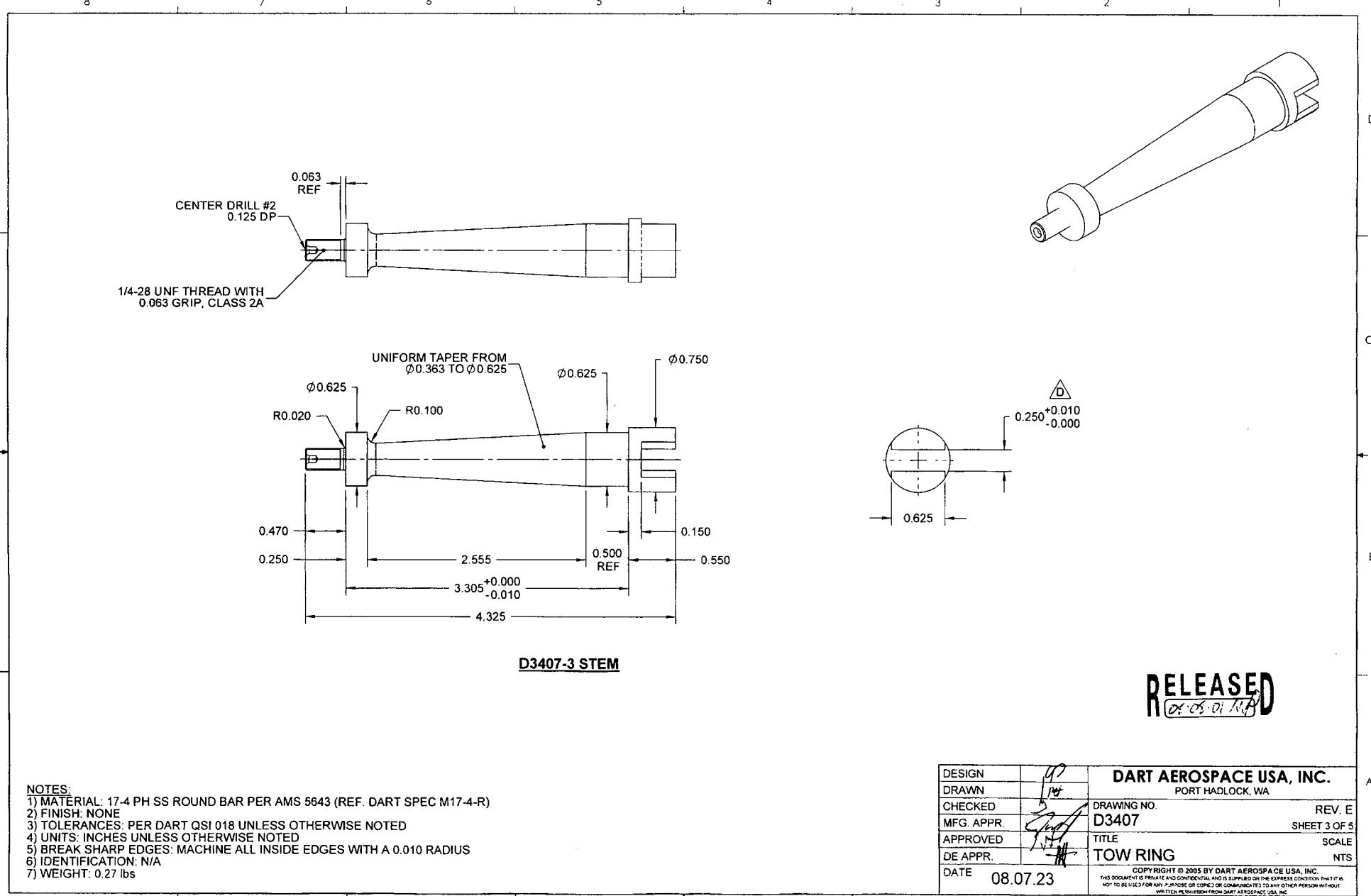
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RELEASED
08-07-01 R/A

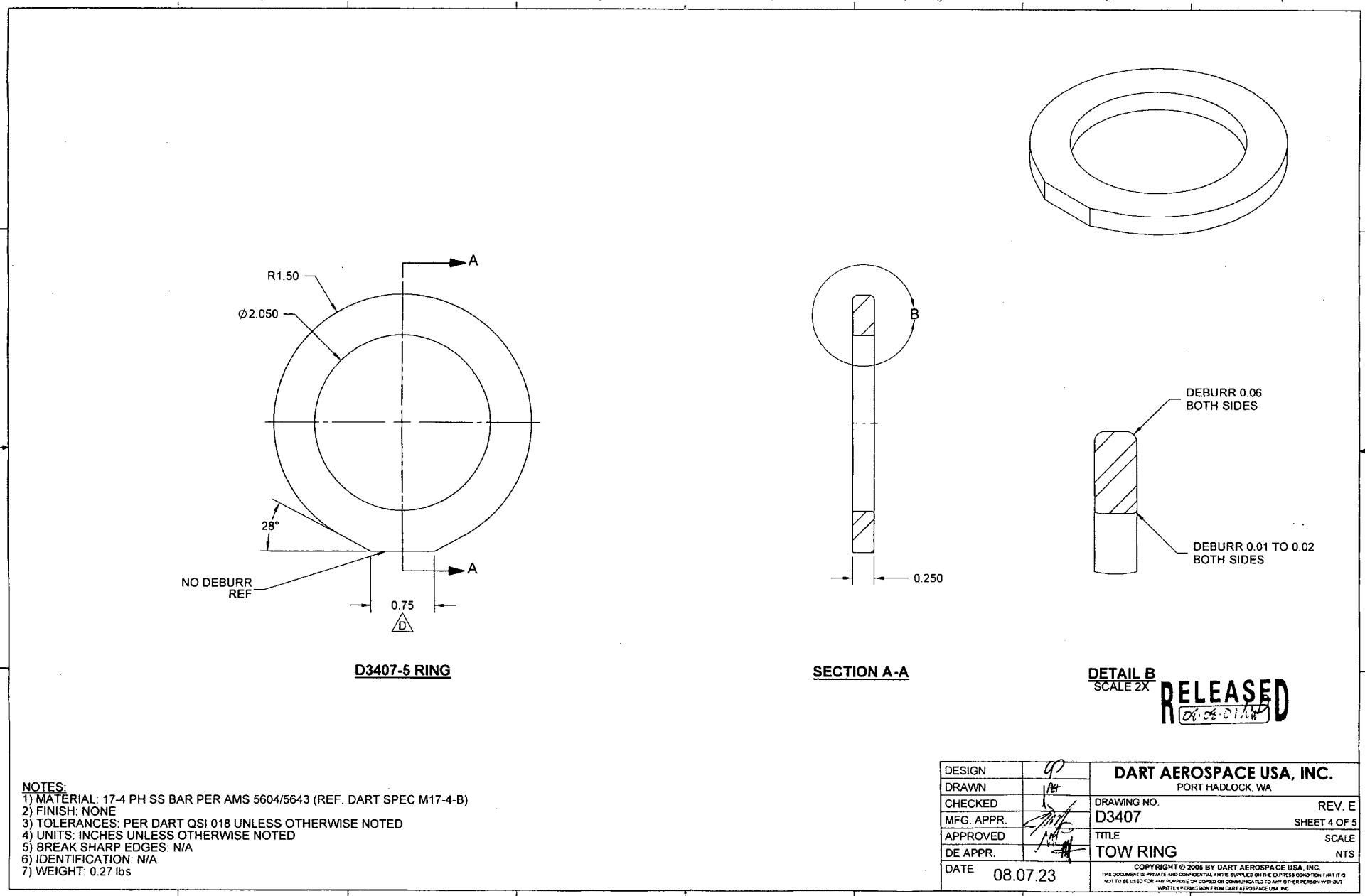
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